

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000474**Date Inspected:** 11-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wenhui Xiong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Mock-Up Assembly-77M**Summary of Items Observed:**

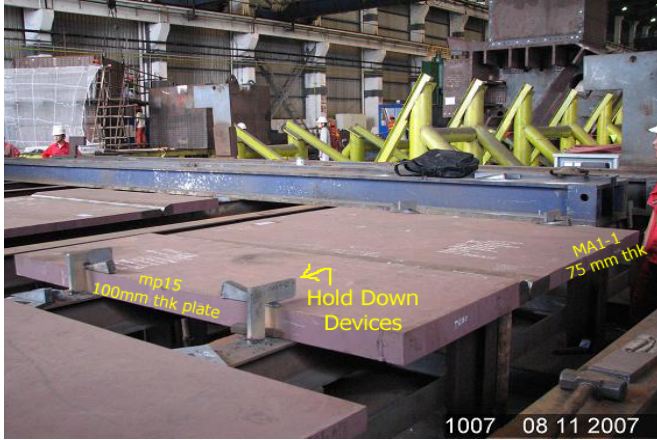
The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77 meters elevation scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge. The QA inspector observed that ZPMC started the joint fit-up for the Tower Mock-up 77 meters elevation skin plate panel E at the junction of the 100 mm (A709-Grade 345) plate mp15 to the 75 mm (A709-Grade 345) plate MA1-1. ZPMC tack welded the hold down devices to the fit-up table frame. ABF representatives Craig Knops, Kevin Carpenter, Warren Buehler, Caltrans Task Leaders Robert Cuellar and Dave McClary, ZPMC representative Xu Jun were present. ZPMC and ABF relayed to the QA inspectors that ZPMC was going to align the plates before tack weld the skin panel E. At the 1530 hours, ZPMC completed the fitting operations for the skin panel E. ABF stopped ZPMC for start welding on the Mock-up 77 meters because ABF and ZPMC had not settled the transportation and personnel logistics for covering of shifts for fabrication at ZPMC Changxing Island.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Acuna,Alfredo  | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Cuellar,Robert | QA Reviewer                 |

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